

Work Order ID 91977

October-19-12 12:46:56 PM

91977

Page 1

Item ID: 647.1401

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assembly

Start Date: 18/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12-10-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1400	N/C								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all mating surfaces per note 2.								
	A/R LOCTITE 598: <u>125174</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

13-4-18

13-4-18

DAS
16
9-83

13/04/19

(Signature)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

Item ID: 647.1401

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assembly

Start Date: 18/10/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 01/11/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

13-4-22

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

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Page 1

Work Order ID: 91977

91977

Parent Item: 647.1401

647 1401

Parent Item Name: Upper Cutter Assembly

Start Date: 18/10/2012

Required Date: 01/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																					
646.9701		Manufactured	No				Each	0.0000		1																								
<div>*646 9701*</div> <div>Cutter Sub Assembly</div> <div>NAS1149FN832P</div> <div>Washer</div>																																		
		Purchased	No		91805		Each	523.0000	**	6		13-4-18																						
<div>*NAS1149FN832P*</div>																																		
<table><thead><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr></thead><tbody><tr><td>275</td><td>198</td><td></td></tr><tr><td>122441</td><td>198</td><td></td></tr><tr><td>ST275</td><td>125</td><td></td></tr><tr><td>115158</td><td>125</td><td></td></tr><tr><td>ST294</td><td>200</td><td></td></tr><tr><td>123352</td><td>200</td><td></td></tr></tbody></table>														Location	Loc Qty	Loc Code	275	198		122441	198		ST275	125		115158	125		ST294	200		123352	200	
Location	Loc Qty	Loc Code																																
275	198																																	
122441	198																																	
ST275	125																																	
115158	125																																	
ST294	200																																	
123352	200																																	
MS27039-08-19		Purchased	No				Each	600.0000	**	3																								
<div>*MS27039-08-19*</div> <div>Screw</div>																																		
<table><thead><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr></thead><tbody><tr><td>ST308</td><td>600</td><td></td></tr><tr><td>123352</td><td>600</td><td></td></tr></tbody></table>														Location	Loc Qty	Loc Code	ST308	600		123352	600													
Location	Loc Qty	Loc Code																																
ST308	600																																	
123352	600																																	
				124579						3		13-4-18																						

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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Picklist Print

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Page 2

Work Order ID: 91977

91977

Parent Item: 647.1401

647 1401

Parent Item Name: Upper Cutter Assembly

Start Date: 18/10/2012

Required Date: 01/11/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

1,234.000

3

MS21042I 08

**

Nut

Location

Loc Qty

Loc Code

315 123900

47

122452

47

ST315

500

122814

500

ST317

687

122141

687

647.1510

Manufactured

No

Each

0.0000

1

647 1510

**

Upper Deflector

125082

1 13-4-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02962				SHEET 1 OF 1	
	DWG NO. 647.1400	REV: N/C	PREPARED BY R. ROSANO	DATE: 09/01/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REPLACED CUTTER BODY IN 647.1401					

STOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 91977 MCT
 12-10-19

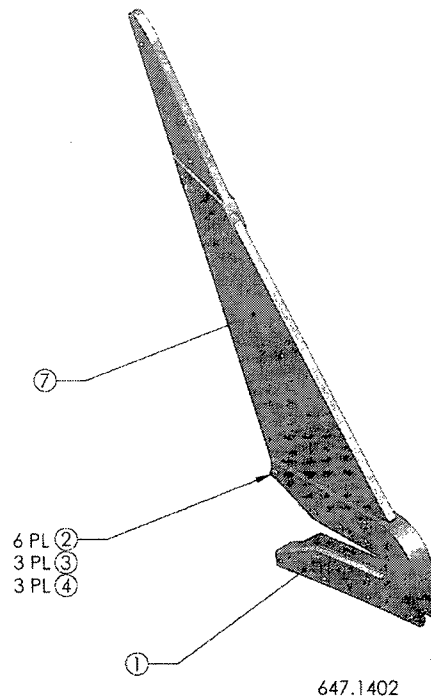
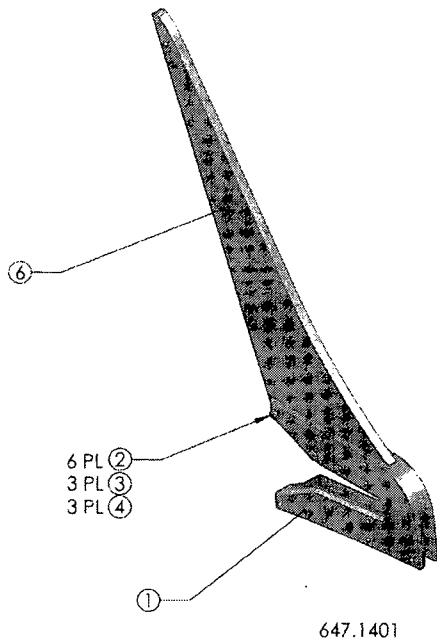
8	A	648.3601		1	CUTTER SUB ASSY		
1	R	646.9701	1		CUTTER SUB ASSY		
F/N	TC	PART NUMBER	1402	1401	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

91977

THE INFORMATION CONTAINED IN THIS DRAWING IS THE PROPERTY OF APICAL INDUSTRIES AND IS UNCLASSIFIED. IT IS TO BE KEPT UNCLASSIFIED AND UNCONTROLLED. IT IS TO BE RELEASED TO THE PUBLIC WITHOUT LIMITATION.

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY



UNINCORPORATED ECN(S)

02962

QTY	1	7	647.1501	LOWER DEFLECTOR ASSY		
		1	6	647.1510	UPPER DEFLECTOR	
A/R	A/R	5	601.2045	RTV, LOCTITE 598		
3	3	4	601.1541	NUT	MS21042-08	
3	3	3	601.2765	SCREW	MS27039-0819	
6	6	2	601.2764	WASHER	NAS1149FN832P	
1	1	1	646.9701	CUTTER SUB ASSY		
			647.1402	CUTTER ASSY (LOWER)		
			647.1401	CUTTER ASSY (UPPER)		
.1402	.1401	FINI	PART #	DESCRIPTION	MAT'L	SPEC.
PARTS LIST						
NEXT ASSY (S)				APICAL INDUSTRIES		
647.1300				2608 TEMPLE HEIGHTS DR.		
				OCEANSIDE, CA. 92056-3512 (760)724-5300		
				CUTTER ASSY		
				REV 647.1400		
				SCALE NONE		
				SHEET 1 OF 1		